

Fire Red

Dart Aerospace Ltd.

Date: Friday, 24/04/2009 12:40:34 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDING PLATE
Job Number	: 47468		
Estimate Number	: 11215		
P.O. Number	:	Part Number	: D33333
This Issue	: 24/04/2009 S.O. No. :	Drawing Number	: D3333 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 46344	Material	:
Written By	:	Due Date	: 10/05/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 09-04-24</u>		
Comment	: Est. A05.01.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010B4000X00500	1010-1025 Steel Bar 4.00 x .500
<p>Comment: Qty.: 0.7984 f(s)/Unit Total: 7.9842 f(s) AISI 1010-1025 Steel Bar Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B4.000x00.500) Identify for D3333-3 Batch: <u>M110740</u></p>		
2.0	BAND SAW	BAND SAW
<p>Comment: BAND SAW Cut blanks: 4.000" x 0.500" thick x 9.620" long</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA483 and Dwg D3333 Identify as D3333-3</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		
5.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK</p>		

W/O: <i>FE</i>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SLIDING PLATE

Job Number: 47468

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE-FABRICATION RESOURCE 1

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

SAD 09-04-28

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/04/28 (X10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

START TIME:

9:25

OVEN TEMPERATURE:

320°

FINISH TIME:

9:55

UMP FR

(X10)

09/05/01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

(X10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST482

SAD 09/05/04 (X10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



mf 09-05-04

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DART AEROSPACE LTD		Work Order:	47468
Description: Sliding Plate		Part Number:	D3333-3
Inspection Dwg: D3333 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.899	✓			
9.50	+/-0.030	9.499	✓			
0.650	+/-0.010	.648	✓			
2.310	+/-0.010	2.310	✓			
1.125	+/-0.010	1.125	✓			
1.950	+/-0.010	1.952	✓			
1.200	+/-0.010	1.200	✓			
1.300	+/-0.005	1.300	✓			
R0.125	+/-0.010	R.125	✓			
0.500	+/-0.010	.493	✓			
0.440	+/-0.010	.434	✓			
1.675	+/-0.010	1.673	✓			
0.035 x 45°	+/-0.010 x 0.5°	.032 x 45°	✓			
0.485	+0.000/-0.010	.480	✓			
1.11	+/-0.030	1.114	✓			
3/8 - 24 UNF	N/A	3/8-24	✓			
0.450	+/-0.010	.440	✓			

Measured by:	AV	Audited by:	SP	Prototype Approval:	N/A
Date:	09/04/20	Date:	09/01/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	BE

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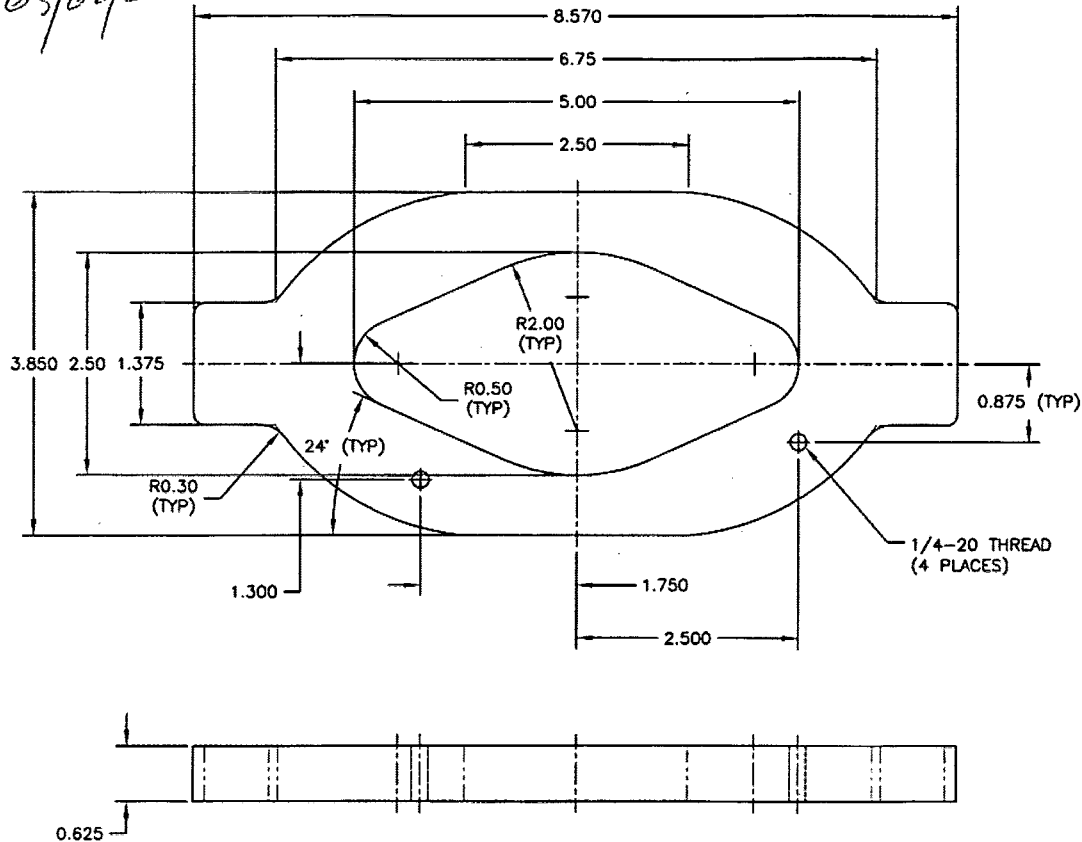
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NOTE: Date & initial all entries

DART

DESIGN TH	DRAWN BY TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED -3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-8) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

RETURN TO
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 47408

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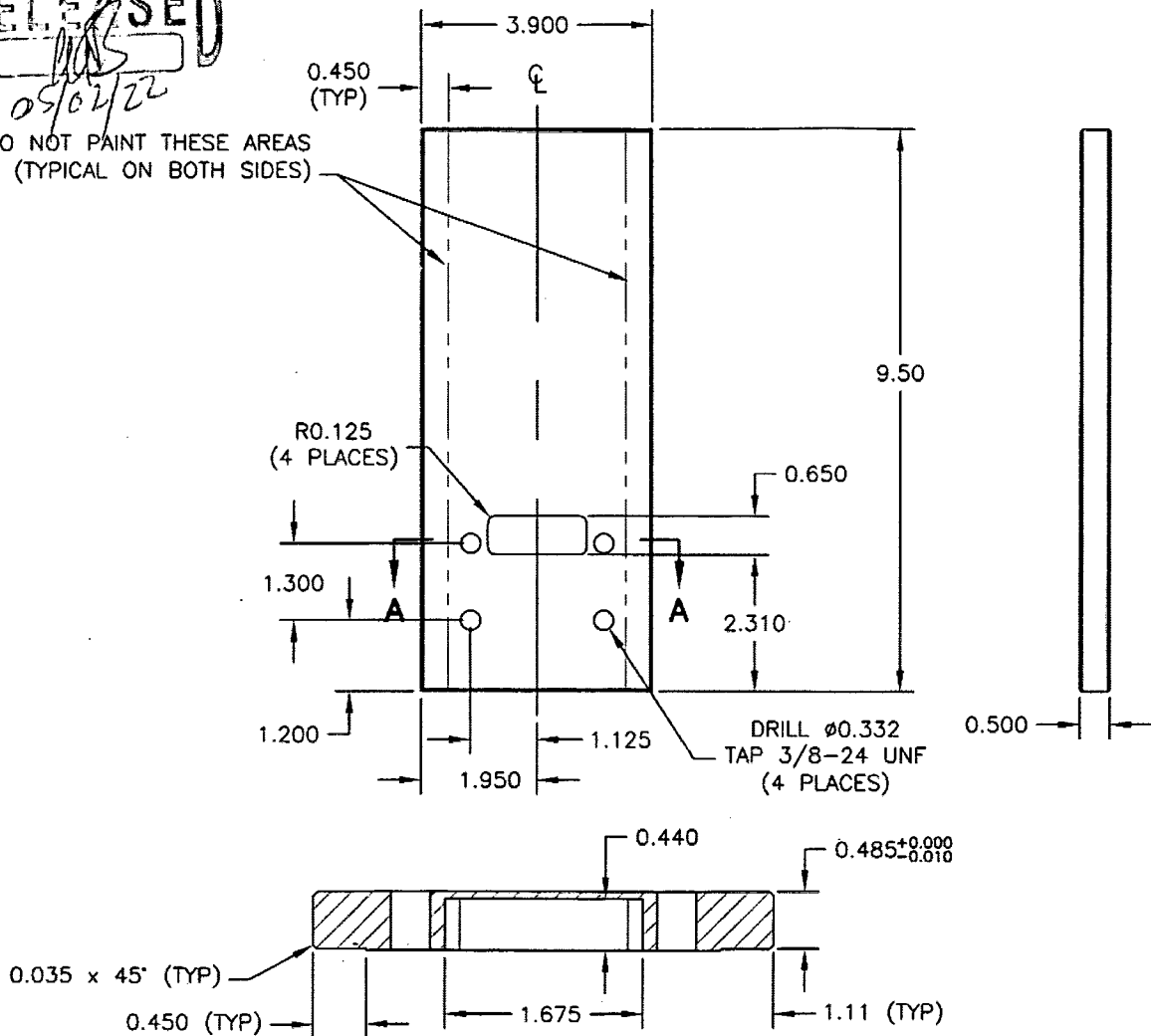
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DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)**SECTION A-A****D3333-3 SLIDING PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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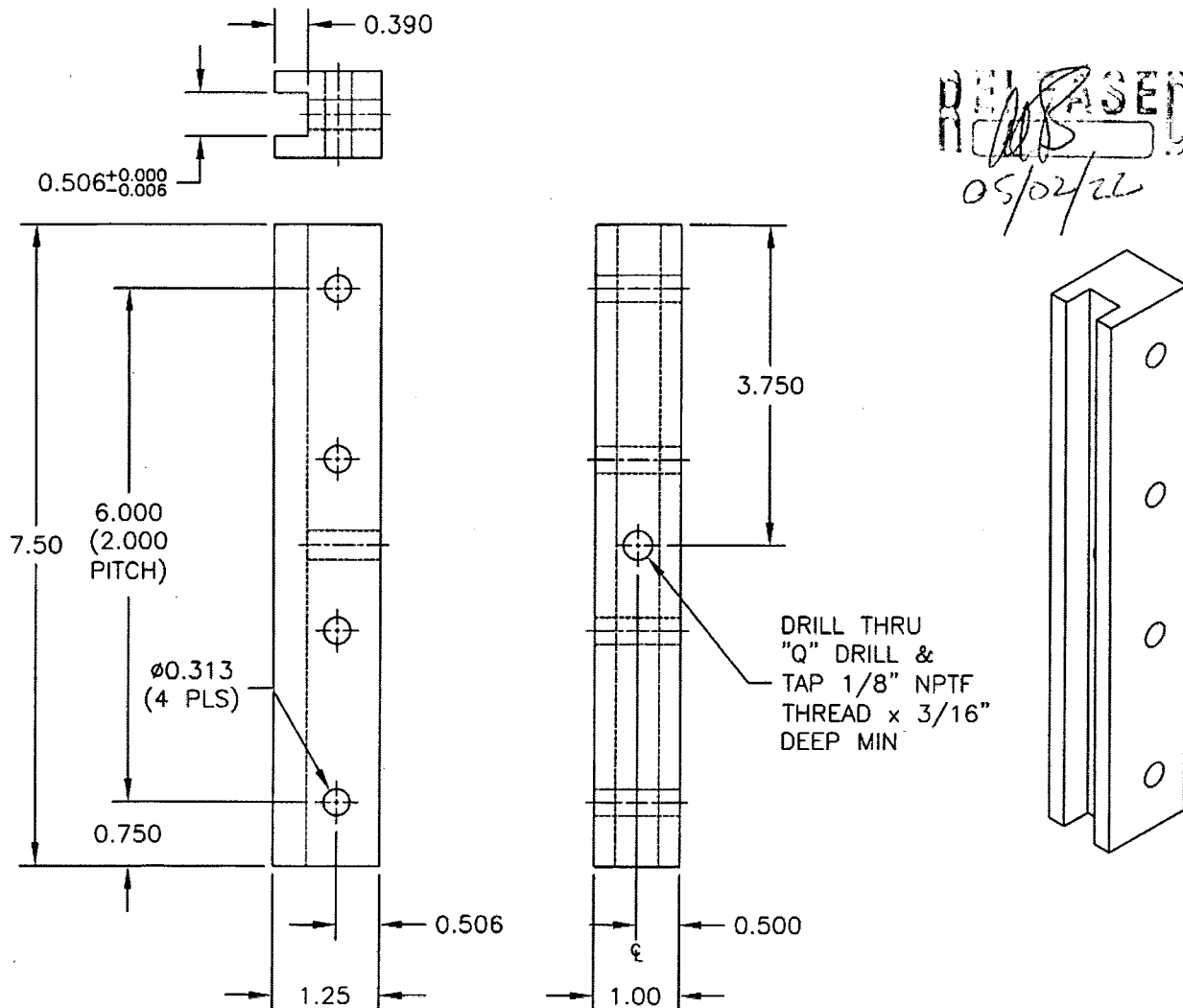
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DART

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:2

**D3333-5 RAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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